

Work Order ID 60917

Monday, July 26, 2010 3:32:10 PM



Page 1

Item ID: D3836-041

Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 7/26/2010 Start Qty: 2.00

Required Date: 8/3/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-7-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: M109213

6- grind weld flush where indicated on dwg

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

2

Cpl 10-07-28

SAD 10-07-28

② 10-07-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60917

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Page 2

Item ID: D3836-041

Revision ID:

Accept



Item Name: Rib Assembly (Basket Lid, LH)

Setup Start



Start Date: 7/26/2010 Start Qty: 2.00

Stop



Required Date: 8/3/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.06.12.9

(X2)

041

150



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

SAD

10-07-29

PC 10.07.28

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/29

PC 10-7-29

(2)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, July 26, 2010 3:32:16 PM

Page 1

Work Order ID: 60917

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3 Spacer Bushing		Manufactured	No			100	Each	31.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		31							
				58406		1							
				58974		1							
				59980		9							
				60320		20							
M304TS0.750W.065		Purchased	No			100	f	617.0387	1.7808	3.749053			
304 SQ Tube .75x.75x.065W				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT		1.4628							
				112398		0							
				114482		1.4628							
				WA		615.575885							
				114520		57.681285							
				115274		557.8946							

Pl 10-07-28

(2)

SAD

10-07-28

9.7491

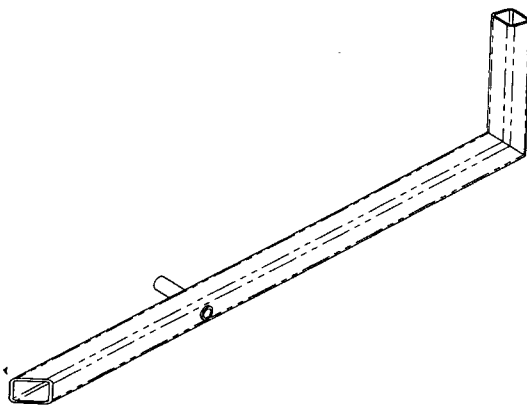
W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

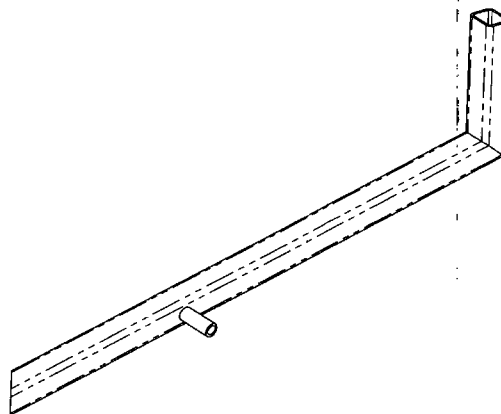
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NOTE: Date & initial all entries



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60947
P/O-724

RELEASED
08/11/14 MB

A	NEW ISSUE		MB	08.09.24
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.09.24			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3836	REV. A
TITLE RIB ASSY (BASKET LID)	SHEET 1 OF 3
SCALE NTS	

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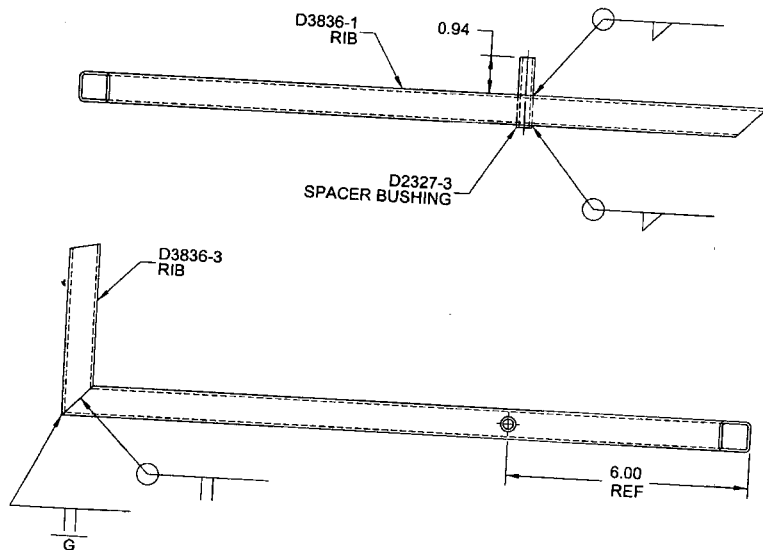
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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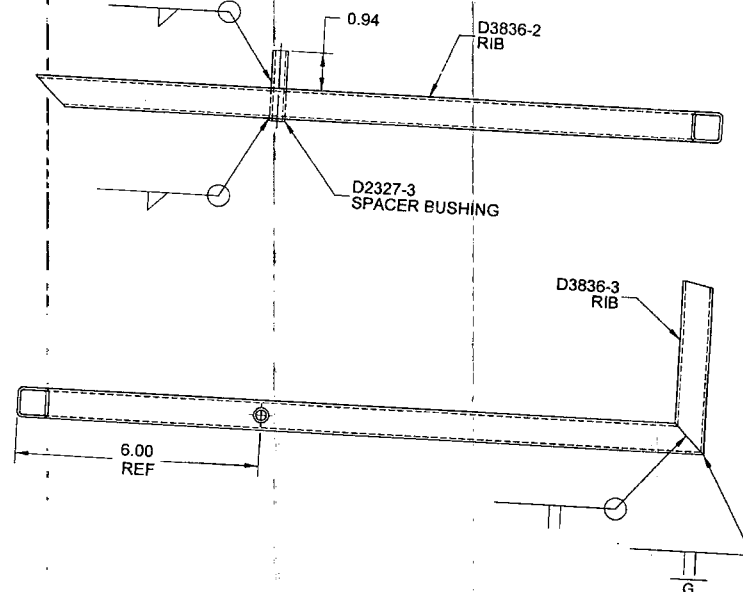
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NOTE: Date & initial all entries



D3836-041 RIB ASSY (BASKET LID, LH)



D3836-042 RIB ASSY (BASKET LID, RH)

W/O 60917
RELEASED
08/11/13 JMT

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3836 TITLE RIB ASSY (BASKET LID) SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPARISON TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
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MFG. APPR.		
APPROVED		
DE APPR.		REV. A SHEET 2 OF 3
DATE	08.09.24	

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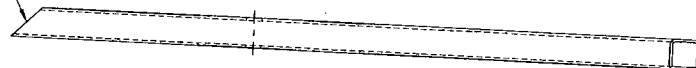
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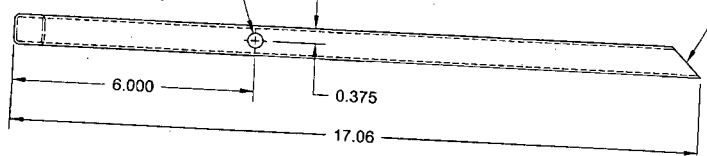
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0.75 X 45°
CHAMFER



$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



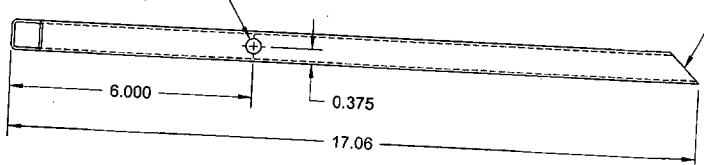
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D3836-1 RIB

0.75 X 45°
CHAMFER

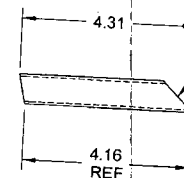


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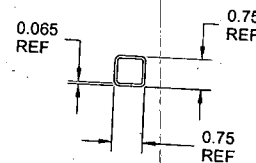
0.75 X 45°
CHAMFER

D3836-2 RIB



0.75 X 45°
CHAMFER

D3836-3 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/07

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	<i>ASS</i>	
CHECKED	<i>ASS</i>	DRAWING NO. D3836
MFG. APPR.	<i>ASS</i>	REV. A
APPROVED	<i>ASS</i>	SHEET 3 OF 3
DE APPR.	<i>ASS</i>	TITLE RIB ASSY (BASKET LID)
DATE	08.09.24	SCALE NTS

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